

Work Order ID 58357

Tuesday, May 04, 2010 10:13:23 AM



Page 1

Item ID:	D3916-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly					
Start Date:	5/4/2010	Start Qty:	8.00			
Required Date:	5/13/2010	Req'd Qty:	8.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-5-4</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3916	A								

100		0.00							
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Large Fab

Large Fab

Memo

- 1- Cut tube 50" DSAD 10-05-04 (8)
- 2- Bend tube with manuel pipe bender as per DT9567 ID
- *** Make line at 9.00" annd use jig for other line***
- 3- Trim access tube material to finish size as per dwg D3916 PD
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605 PD
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

(4) PD 10.05.06
(4) PD 10/05/06

110	QC5- Inspect part completeness to step on W/O	0.00							
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QC

Quality Control

Memo

0.00

Subs/06

(15)

3 2 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58357

Tuesday, May 04, 2010 10:13:23 AM



Page 2

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 5/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	S. 10.6.5.106			(10)			
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>box</u> Memo	0.00 0.00				8	PD 10.05.07		
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/05/07 <i>AG</i> MF 10-5-7

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Picklist Print

Tuesday, May 04, 2010 10:13:23 AM

Page 1

Work Order ID: 58357

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Date: 5/4/2010

Required Date: 5/13/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	112.0000	7			
Bushing												

Location

Loc Qty

Loc Code

WA	112	
54072	9	
57852	3	
58159	100	

M304TS0.750W.049

Purchased

No

100

f

590.8285

4.166

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT	200	
113763	0	
114323	200	
MAT017	390.8285368	
113763	24.25	
114270	200	
114298	166.578537	

37.494
4.166 x 9 = 37.494
~~33.328~~
39.3687 with
5%
waste

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

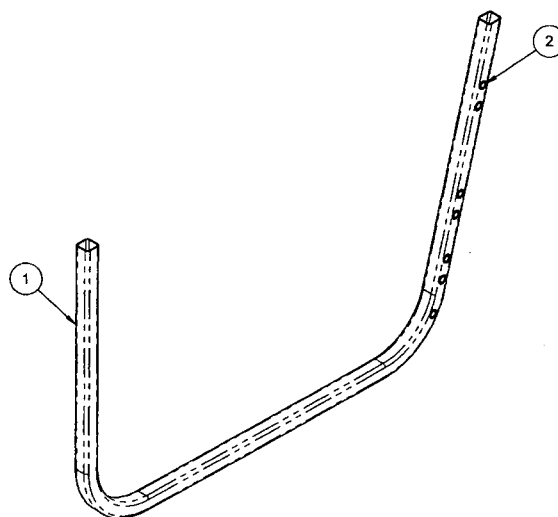
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

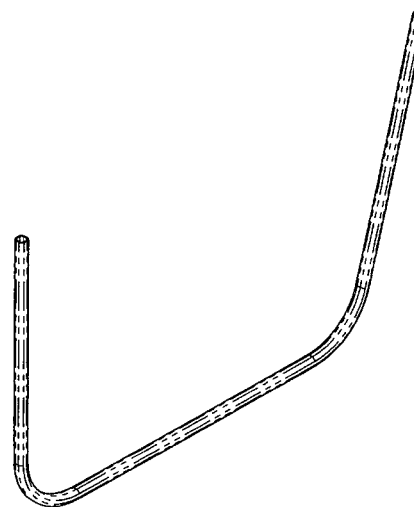
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

#58357

RELEASED
2010-03-12
JWP

REV	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3916 TITLE RIB ASSY, 350 BASKET SCALE NTS	BY	DATE
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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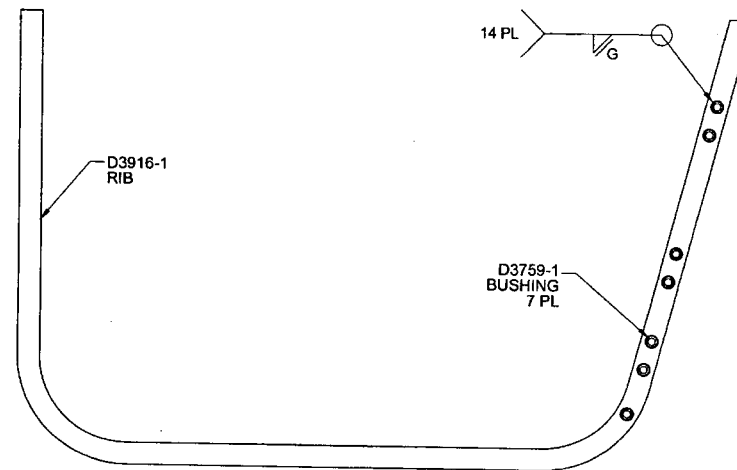
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

#58357



D3916-041 RIB ASSY

RELEASED
2010-03-12
AMP

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT -041: 1.84 lbs
 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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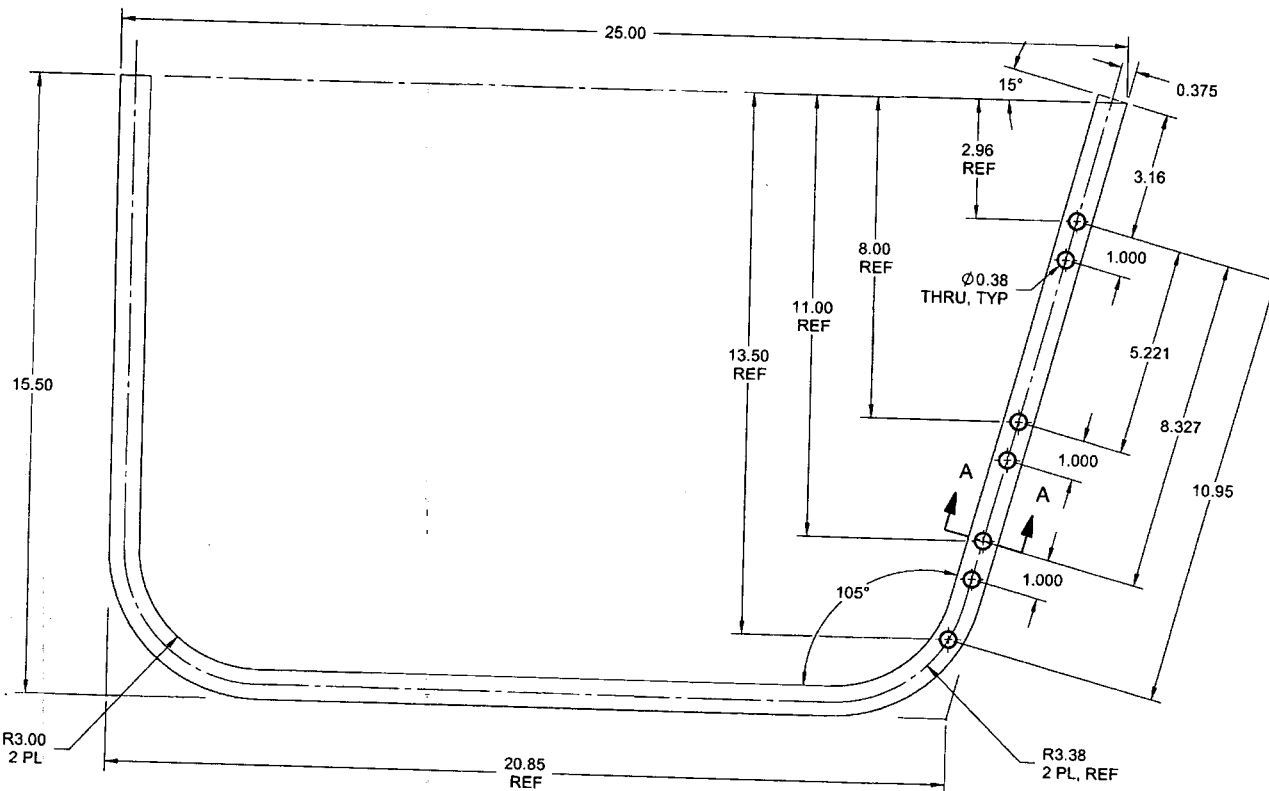
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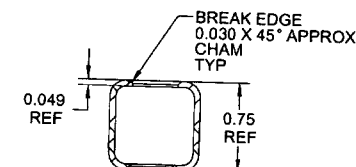
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NOTE: Date & initial all entries



#58357



SECTION A-A

9 D3916-1 RIB

RELEASED
2010-03-12
NAD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

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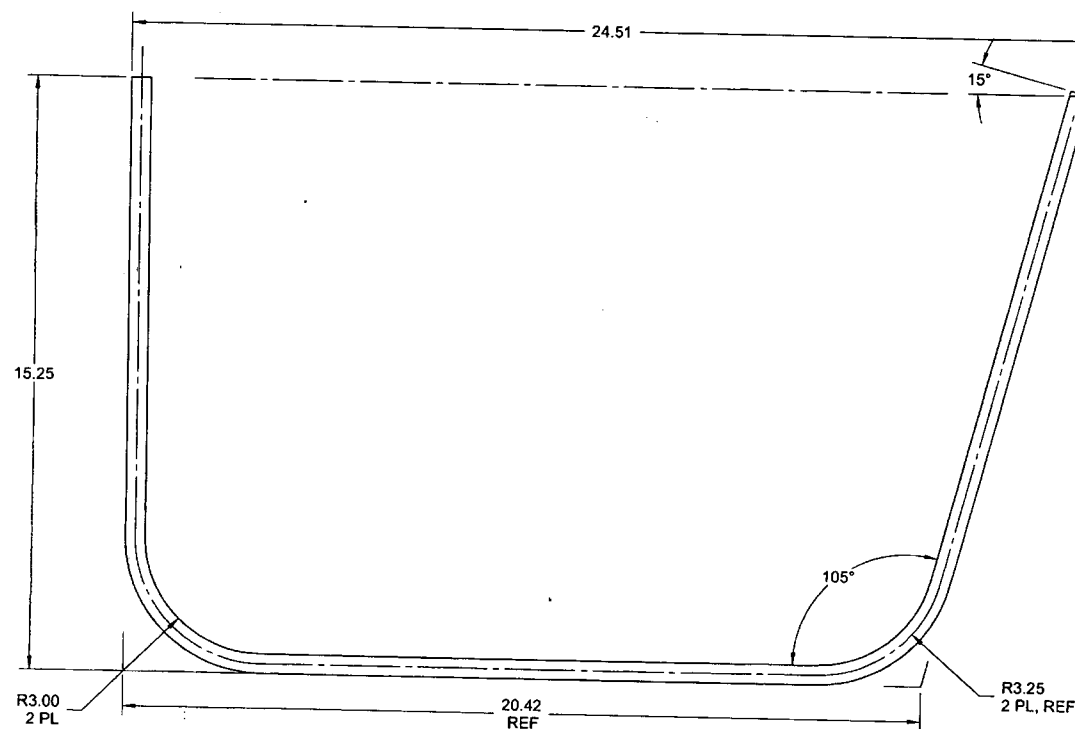
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9) D3916-5 LIGHT RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

RELEASED
2010-03-12

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
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